Work Ord Monday, July 14				*122	2347*						Page	1
Item ID: Revision ID: Item Name:	D3573-3 Adapter			Accept	*N900	040	100)* ·	Setup Sta		JS1* JS2*	
Start Date: Required Date:	7/14/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				•		
Reference: Approvals:	Process P	lan: MLJ	Date: \\\-\\\\-\\\\\\\\\\\\\\\\\\\\\\\\\\\\	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	/ ^ q	JR1* JR2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp	
Draw Nbr D3573		evision Nbr										
100 *100 * Bandsaw	N.C.	BAND SAW Memo		0.00				4	Ø		DAS 20 /	4-07-2
Jeaspa Bandsaw		Cut blank	3.500" long									·
*110 *110*		HAAS CNC VERTICA	L MACHINING #1	0.00				4			DAS 25 9-89	17-24
HAAS 1 HAAS CNC vertice	al machine #1	Memo Machine as	s per Folio FA673 and Dwg	0.00 D3573								-
120		OC2 Inspect parts off	maghina FAI/FAIR	0.00								

0.00

Memo

120

Quality Control

DQA:			Date:						•				TDART
						WORK ORDER NON-	-co	NFO	RMANCE / UP		ork Order up	odate only	AEROSPACE
QA Closed:			Date:							Į VV	ork Order up	date only	
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WOIK OIGE	-					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1 1		noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite		Supplier	
	•												
Root					Desc	ription of work order update	In	itial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Chie	ef Eng	Descri	ption	Date	Verification	QC Inspector
Design													
Doc/Data										,		•	
Equip/Tooling							1						
Handling/Pre													
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Operator													
Offset/Setup	_												
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Supplier	_												
Training	_							•					
Transport								} ,					
Unapproved							FALL	UT CAT	TEGORY				
1	6					General	FAU	LICA	IEGONI	- 	 		
Landir		Bending				Bend		 Folio/E	Program		Outside Dim	ensions [Pressure/Forced
}	-	Centre No	nt Concer	ntric	\vdash	BOM/Route	\mathbf{H}	Grain	10gruiii		Over/Under	 	Set-up
}	-	Cracks	or concer	iti it		Broken/Damage/Defect	-	Hardwa	are		Part Incorre	_	Temperature/Cure
}		Crimp/Kir	nk/Rinnle	/Wave		Burrs	\mathbf{H}		ion Incomplete/Un	gualified	Part Lost/Mi		Weld
7		Cuffs	по парые,	, ,,,,,,		Contamination	\vdash		tions Incomplete/U	· -	Part Moved	Ĭ	Wrong Stock Pulled
: \$	-	Crushing				Countersink	\vdash		gned/off center		Positioned V	Ŭ Vrong	_
. }		Heat Trea	ıt			Cut Too Short	\vdash	Mislabe	-		Power Loss/	Surge	Other.
		Inspection		Tube		Drawing		Misrea	1				
		Marks/Ch				Drill Holes	\square	Off-set					
		Turning S				Finish	\square	Out of	Calibration				
!		Wave/Tw	ist in Tub	ne .		Fit/Function	П	Out of	Sequence				

Work	Orde	r ID	122347
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122347

Page 2

Monday, July 14, 2014 1:56:40 PM Accept D3573-3 Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Adapter *4* Start Otv: 4.00 Start Date: 7/14/14 **Cust Item ID:** Rea'd Otv: 4.00 Required Date: 7/14/14 */* Customer: Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop Date: **SPC** (Y/N): Date: OC: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Oty** Otv Number **Work Center ID** Description Run Hours Code Stamp 0.00 DAS 130 OC8- Inspect parts - second check *130* Ø 0.00 Memo Quality Control Chemical Conversion Coat per OSI005 4.1 0.00 140 4 7/4724 *140* HandFinish 0.00 Memo Hand Finishing DAS 150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 41 *150* 125028 4 0___ 9-89 0.00 Powdercoat Memo 14-7-27 START TIME: **5**: **∞** OVEN TEMPERATURE: Powder Coating 320 FINISH TIME: 530

DQA:			Date:												"DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				Г	_	AEROSPACE
QA Closed:			Date:							\	Nork Orde	r upo	date only		
Work Orde						DISPOSITION				AGAINST C	DEPARTMI	ENT/I	PROCESS		
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Part N	lo.					Scrap			Machining	Small Fab		Prod	I. Eng. Coor.	ヿ	Quality
	•					Use-as-is			noforming	Finishing	Rec/	Store	e/Packaging		Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date		Verification	1	QC Inspector
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;/ v	<u> </u>	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain					tolerance ,	-	•
. Y.	\vdash	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Inc				Temperature/Cure Weld
	_	Crimp/Ki	nk/Ripple	:/Wave	<u> </u>	Burrs	<u> </u>	-l '	ion Incomplete/Un	-	Part Los		ssing	-	
	_	Cuffs				Contamination	\vdash	-	tions Incomplete/U	inclear	Part Mo		lrong L		Wrong Stock Pulled
	L	Crushing			<u> </u>	Countersink	-	-	gned/off center	-	Position				Other
		Heat Trea			\vdash	Cut Too Short	_	Mislabe		Ĺ	Power l	055/5	ourge [Other
	-	Inspectio		Tube	<u> </u>	Drawing	\vdash	Misrea	F.						
	_	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set	[—	
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Wo	rk (Ord	er I	\mathbf{D}	122	347
7 T V	1 IN 1	O L U			-	JTI

Work Order ID Monday, July 14, 2014			*122	347*				Pa	ge 3
Item ID: D3573-Revision ID: Item Name: Adapter			Accept	*N90004	.010	0* s	Setup Star Stop	1.7.2.1.	
Start Date: 7/14/14 Required Date: 7/14/14 Reference:	Start Qty: 4.00	*4* *4*		Cust Item ID: Customer:					
Approvals: Proce QC: _	ss Plan:	Date:	Tooling: SPC (Y/N):	Date: Date:		F	Run Star Stoj		_
Sequence ID/ Work Center ID 160 *1 AA* QC Quality Control	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Sto	ick Location: <u>GA</u>	Set Up/ Run Hours 0.00 ///07/ 0.00	DAS	ol # Plan Code	Accept Qty	28	Reject Insp. Number Stam JUL 2 8 2014	
Packaging Packaging 180 *1 20* QC Quality Control	Memo QC21- Final Inspection - Memo	Work Order Release	0.00				9-69	1/7/29 MF 14-7	-28

DQA:			Date:							<u> </u>			*DART
04 (11-			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Vork Order u	ndate only	AEROSPACE
QA Closed:			Date:				_			<u> </u>	VOIK OTGET G	puace only	
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	,
WOIK OIG	- ' ' -					Rework			Skid-tube	Crosstube	\neg	Water Jet	Engineering
Part N	Jn.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
·						Use-as-is			moforming	Finishing	_	re/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite		Supplier	
	•						'						
Root					Desc	ription of work order update	1	nitial	Acti	φn	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
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Equip/Tooling										1			
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Material													
Operator			i l										
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Transport		*			,								
Unapproved			<u> </u>		<u> </u>								
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Landi	ng (1			_	General		1 /-	_	Г	٦	. г	¬¬¬¬¬¬¬
	$ldsymbol{ld}}}}}}$	Bending			\vdash	Bend	<u> </u>	4	Program	<u> </u>	Outside Dir	<u> </u>	Pressure/Forced
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	_	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	}−	Temperature/Cure
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	\vdash	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set	Calibration				
	H	Turning S			\vdash	Finish Fit/Function		-	Sequence				
			131 111 1111	45		11 11/1 (4111.411/11)	4	TOUL OF	JUNGUICE 1				

Picklist Print

Monday, July 14, 2014 1:56:40 PM

Work Order ID: 122347

122347

Parent Item:

D3573-3

D3573-3

Parent Item Name: Adapter

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50		Purchased	No			100	f	20.7920	0.292	1.229474			DAS
*M6061T6	SRO SOO	Y02 50	\ ∩ *						** (233		-	20

6061-T6 Bar .500 x 2.50

Location		Loc Qty	Loc Code	
MAT001		20.792		
	124443	2		
	M128247	18.792		1.533

Page 1

DQA:			Date:	.										"DART
OA Clasadi			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UP	DAIE	W	ork Order up	ndate only	AEROSPACE
QA Closed:			Date.	-										
Work Orde	r.					DISPOSITION	i			AGAINST	Γ DE	PARTMENT,	/PROCESS	
Work Orac	•					Rework	1		Skid-tube	Crosstube	,]	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing	\mathbb{Z}	Rec/Sto	re/Packaging	Other
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		<u> </u>							T	ļ 1		C: 0		<u></u>
Root					Desci	ription of work order update	ı	Initial	Acti	1		Sign &	Varification	OC Inspector
Cause	:	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector
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Equip/Tooling	_											ļ		
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Landii	ng (Gear				General		_			_	-	_	-
		Bending				Bend		Folio/F	Program			Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L	Grain			_	Over/Under	 	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	•		L	Part Incorred	 	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Un	qualified	<u>_</u>	Part Lost/Mi	issing	Weld
		Cuffs				Contamination		4	tions Incomplete/U	nclear		Part Moved		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink		-	gned/off center			Positioned V		٦
		Heat Trea	nt			Cut Too Short	_	Mislab			L	Power Loss/	Surge	Other
		Inspection		Tube		Drawing		Misrea						
		Marks/Ch				Drill Holes		Off-set						
		Turning S	•			Finish		-	Calibration					
		Wave/Tw	ist in Tub	16		Fit/Function	i i	lOut of	Sequence					

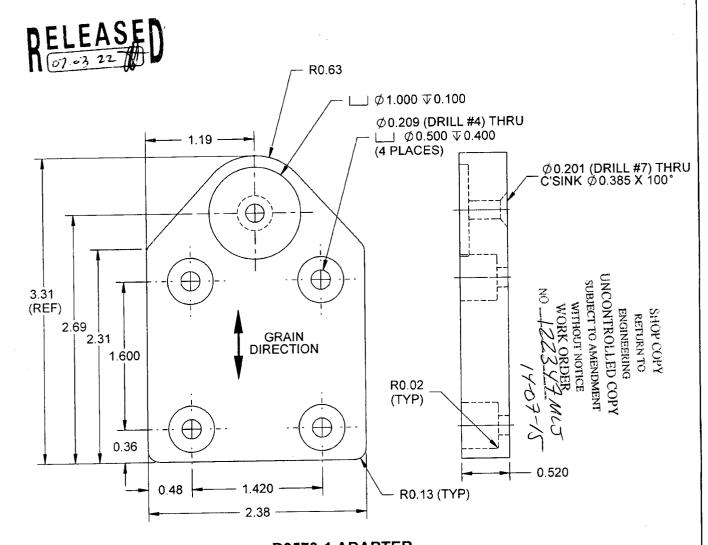
DART AEROSPACE LTD	Work Order:	122347
Description: Adapter	Part Number:	D3573-3
Inspection Dwg: D3573 Rev: A		Page 1 of 1

inspection bwg.		T ARTICLE	INSPECT	ION CHE	ECKLIST		
	_	First Art	_		otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
3.31	+/-0.030	3:310			Noil	77-10	<u> </u>
2.69	+/-0.030	2.69					
2.31	+/-0.030	231					
1.600	+/-0.005	1-600					
0.36	+/-0.030	-359	/				· · · · · · · · · · · · · · · · · · ·
1.19	+/-0.030	1-189			1465		
2.38	+/-0.030	2375					
1.420	+/-0.010	1.420					
0.48	+/-0.030	.479					
R0.63	+/-0.030	-63					
R0.13	+/-0.030	-13					
R0.02	+/-0.030	-015				<u> </u>	
Ø0.209	+0.005/-0.001	209					
Ø0.266	+0.006/-0.001	-267		,,,,,			
0.390	+0.010/-0.000	392					
Ø0.675 x 0.190	+/-0.010	-675X.188					
Ø0.500 x 0.310	+/-0.010	1497X.310			1		
			DAS				
Measured by:	//	Audited by:	9-89		Prototype Ap	proval:	N/A
Date:	4-7-24	Date:		1/24		Date:	N/A
Rev Date	Change		-		R	evised by	Approved

Rev	Date	Change	Revised by	Approved
Α	07.04.04	New Issue	KJ/JLM A	721/



	DESIGN	DRAWN BY		AEROSPACE SBURY, ONTARIO, CAN	
	CHECKED	APPROVED.	DRAWING NO.		REV. A
	PH		D3573		SHEET 1 OF 4
	DATE		TITLE		SCALE
	07.02.19		ADAPTER		1:1
-	REV	DATE		DESCRIPTION	
		07.02.19	NEW ISSUE		



D3573-1 ADAPTER

NOTES: 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

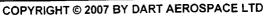
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

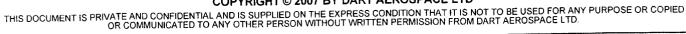
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

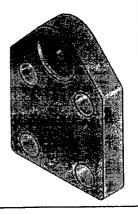
4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

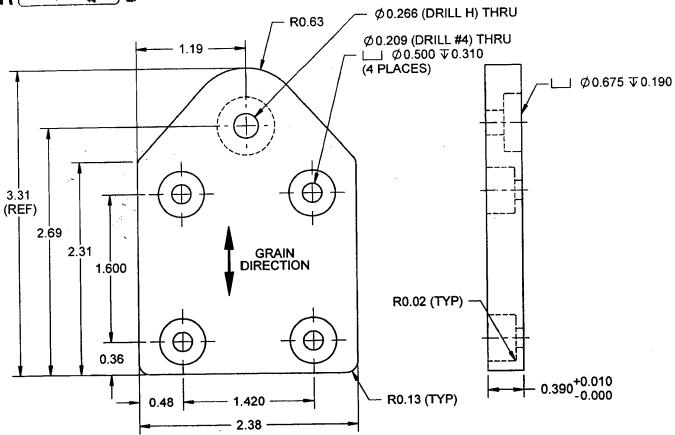








DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3573	REV. A SHEET 2 OF 4
DATE 07.02.19		ADAPTER	SCALE 1:1



D3573-3 ADAPTER

NOTES: 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

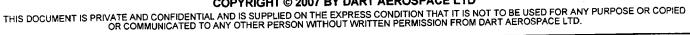
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

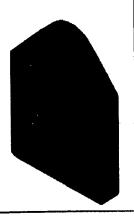
4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

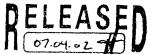


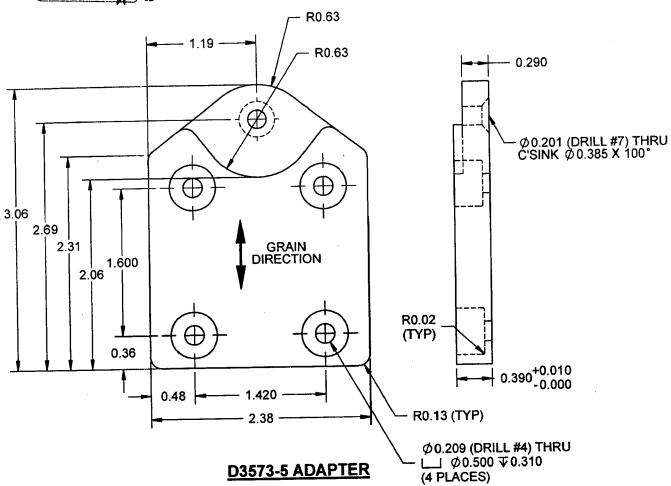






DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3573	REV. A SHEET 3 OF 4
DATE 07.02.19		ADAPTER	SCALE 1:1





1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M606176B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

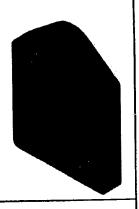
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



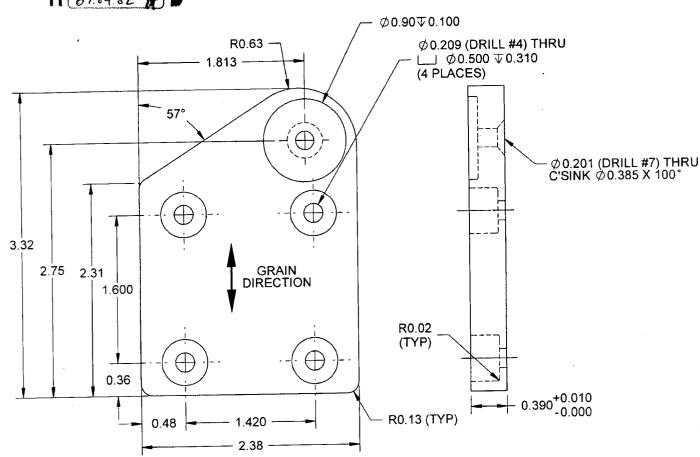
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	-	D3573	SHEET 4 OF 4
07.02.19		TITLE	SCALE
		ADAPTER	1:1

RELEASED



D3573-7 ADAPTER (SHOWN) D3573-8 ADAPTER (OPPOSITE)

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

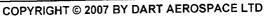
(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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